

4130 - 750

Work Order ID 72238



Page 1

Wednesday, July 20, 2011 9:07:22 AM

Item ID: D3028-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud

Start Date: 7/20/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

CL

Date: 11/07/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3028	Rev A								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn blank per Dwg D3028 and FA263

CL 11/8/17

12 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

CL 11/8/17

12 0

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Cut groove as per Dwg D3028 and FA

2-Deburr

FK 11/12/12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 7/27/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

6/20/11 (12)

165

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/2/01/10

(12)

Quality Control

170

Identify as per dwg & Stock Location ST 24. 0.00

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached
Identify and Stock

(12) 12-01-12.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3028-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud

Start Date: 7/20/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/1/16
ME
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 9:07:20 AM

Work Order ID: 72238



Parent Item: D3028-1



Parent Item Name: Stud

Start Date: 7/20/2011

Required Date: 7/27/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPPB 02.09.10 Made on Cobra KJ
IPP C 08.11.06 Added QC6 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750 		Purchased		No		110	f	10.6200	0.125	1.578947			

4130 steel RD bar .750"

Location

MAT031

111823

Loc Qty

10.62

10.62

Loc Code

126 ft

11/8/17

W/O:		WORK ORDER CHANGES					
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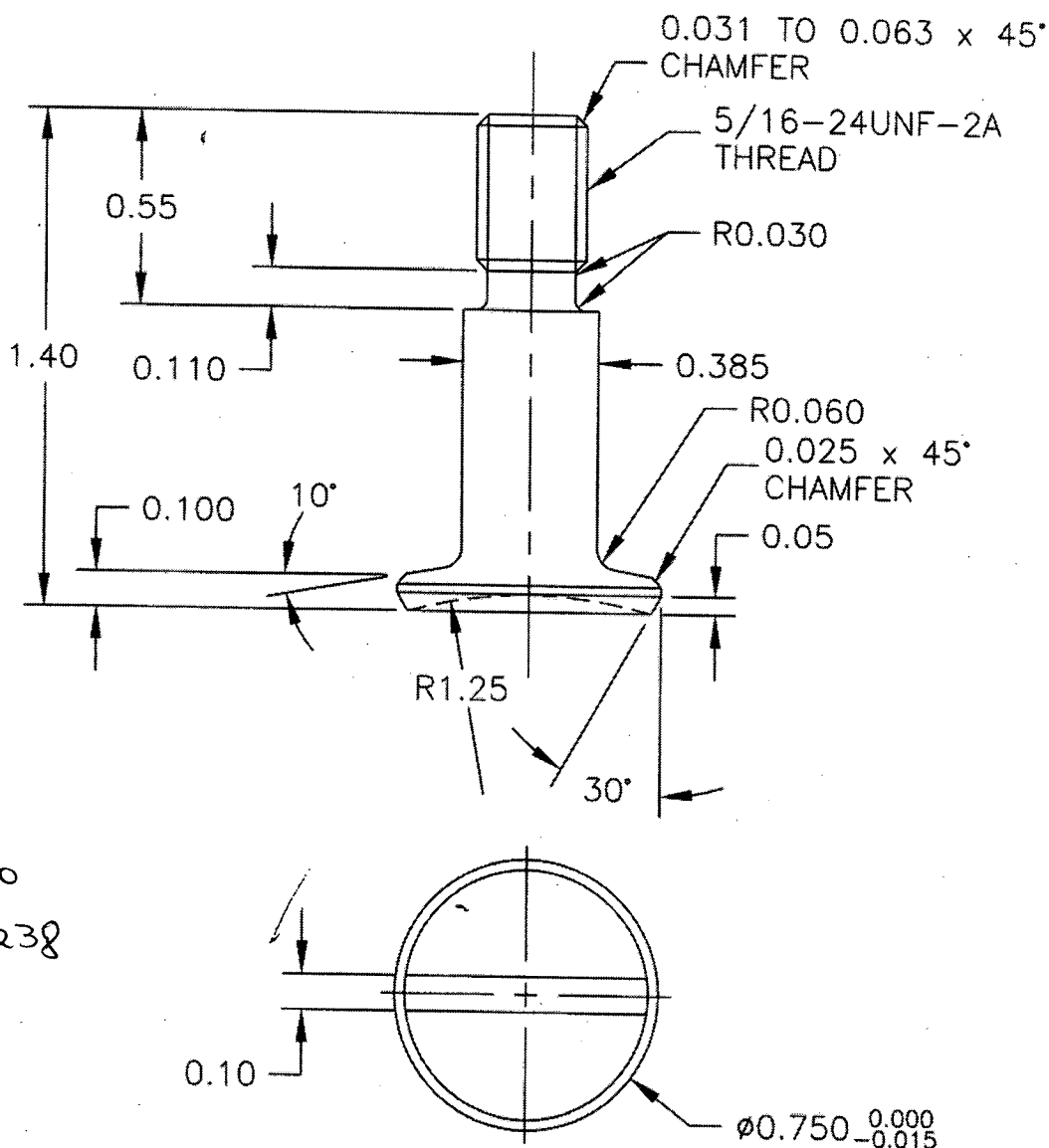
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



CL11107120
W/OS 72238

D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15678

Purchase Order Date 12/14/11

PO Print Date 12/14/11

Page Number 1 of 1

Order From :

vc-leg006

LEGO FINISHING CERNTER INC.
6880 BOULV CAUTURE
MONTREAL, QC HIP 2W6

Contact Name

Vendor Phone

514 323 4131

Vendor Fax

514 323 9093

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 12/14/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	72238	D3028-I STUD	12/22/11 Yes	12.00	FedEx PI collect	\$12.5000	\$150.00

Special Inst: CADMIUM PLATE PER QQ-P-416F
CLASS I TYPE II

PO Total:

\$150.00



CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 12/14/11



Lego Centre De Finition Inc.

6880 Couture, St-Léonard, QC. H1P 2W6
tel (514) 323-4131 fax (514) 323-9093 Lego Finishing Center Inc.

CERTIFICATE OF CONFORMITY
CERTIFICAT DE CONFORMITÉ



C of C Number : 108549

Cert Rev 0 DWG Rev A

Page: 1 of 1

C of C date 04 Jan 2012

PO Number : 15678

C of C Generator Mustapha Benachour

Material ST 4130 CON. ANNEALED

Customer

DART AEROSPACE

1270 ABERDEEN STREET
HAWKESBURY, ON.
K6A 1K7

CHANTAL LAVOIE TEL: 613-632-5200

5/12/10

LINE ITEM DETAIL - PARTS DESCRIPTION

Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	D3028	1		B 72238		12	0	12	

THE FOLLOWING PROCESS(ES) WERE APPLIED TO THE COMPONENTS MENTIONNED ABOVE

#	Required Process Name	Spec Number	Rev.	Process description
1	CD QQ CD/ST CL 1	AMS QQ-P-416	C	CADMIUM PLATED CLASS 1 PER AMS QQ-P-416 AND LEGO PROCESS 203 THICKNESS: .0005 - .0008
2	TY2 TYPE 2			CHROMATE CONVERSION

Customer Additional Info:

Je certifie que les articles inscrits ont été inspectés et mis à l'essai et qu'ils sont conformes aux spécifications et exigences du contrat ou du bon de commande. / I certify that the items listed herein have been inspected and tested and conform to all specifications and requirements of the contract or purchase order.

La responsabilité de Lego Centre de Finition inc se limite à la valeur de notre procédé effectué sur vos pièces. Toute réclamation doit être faite dans les 10 jours suivant la réception de vos pièces.

The liability of Lego Finishing Center inc is limited to the value of the process performed on your parts. All claims must be made within 10 days after receiving your parts.

Signature:

[Signature]

Stamp:



Date:

04 JAN. 2012